

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019708**Date Inspected:** 26-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** SHANGHAI CHINA**CWI Name:** Mr. An Qing Xing.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG TRIAL ASSEMBLY**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

CB # 16

Shielded Metal Arc (SMAW) welding of Weld Joint FB203-016-010 (CB 16), And Welder is identified as 041713; ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables appeared to comply with the Applicable WPS- B-P-2114-FCM-1.

Lift 11W

Flux Cored Arc (FCAW) welding of Weld Joint TRIC-PP102-006 (11W,Traveler Rail Bracket),And Welder is identified as 053486; ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Hai. The welding variables appeared to comply with the Applicable WPS-B-T-2233-TC-U4c-F.

LIFT 11W:-

Shielded Metal Arc (SMAW) welding of Weld Joint SEG071A-044 (11DW,CW Side), And Welding Repair

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Report(WR)B-WR17735, Welder is identified as 046709; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair.

Shielded Metal Arc (SMAW) welding of Weld Joint 0BW11C-009 (11DW+11EW, SP-SP, CB Side), And Critical Welding Repair Report(CWR)B-CWR2269, Welder is identified as 046704; ZPMC Quality Control (QC) is identified as Mr. Zhu Peng. The welding variables appeared to comply with the Applicable WPS-345-SMAW-3G(3F)-FCM-Repair.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG073A-013 (11EW, CW Side), And Welding Repair Report(WR)B-WR17735, Welder is identified as 040611; ZPMC Quality Control (QC) is identified as Mr. Zhu Peng. The welding variables appeared to comply with the Applicable WPS-345-SMAW-1G(1F)-FCM-Repair.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07503

Ultrasonic Testing (UT)

This QA Inspector performed UT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The member is identified as Bike Path Cantilever Beam welds. The weld designations reviewed are as follows.

1. BK001-048-005,006,007,009
2. BK001-049-005,006,007,009

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07502

Ultrasonic Testing (UT)

This QA Inspector performed UT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The member is identified as 11EW PP108 Strengthen Plate welds. The weld designations reviewed are as follows.

1. CSD9-PP108-150~153

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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